

WHAT IS CLAIMED IS:

1. A method for peeling a lens sheet having two pairs of opposite portions from a forming mold, comprising:

5 a first peeling step for pulling up a pair of opposite portions of a lens sheet, which is formed on a forming mold, to peel partially said lens sheet from said forming mold;

a second peeling step for pulling up an other pair of opposite portions of said lens sheet to peel partially said lens sheet from said forming mold; and

10 a third peeling step for pulling up further said two pairs of opposite portions to peel entirely said lens sheet from said forming mold.

2. The method as claimed in Claim 1, wherein:

15 said first peeling step and said second peeling step are conducted simultaneously.

3. The method as claimed in Claim 1, wherein:

said first peeling step and said second peeling step are conducted at a different time.

4. The method as claimed in Claim 2 or 3, wherein:

20 said first peeling step is conducted by pulling up said pair of opposite portions simultaneously; and

said second peeling step is conducted by pulling up said other pair of opposite portions simultaneously.

5. The method as claimed in Claim 2 or 3, wherein:

25 said first peeling step is conducted by pulling up said pair of opposite portions simultaneously; and

5 said second peeling step is conducted by pulling up said other pair of opposite portions at a different time.

6. The method as claimed in Claim 2 or 3, wherein:

10 said first peeling step is conducted by pulling up said pair of

5 opposite portions at a different time; and

15 said second peeling step is conducted by pulling up said other pair of opposite portions simultaneously.

7. The method as claimed in Claim 2 or 3, wherein:

10 said first peeling step is conducted by pulling up said pair of

5 opposite portions at a different time; and

15 said second peeling step is conducted by pulling up said other pair of opposite portions at a different time.

8. The method as claimed in Claim 1, further comprising:

15 a pressing step for pressing a central portion of said lens sheet

10 against said forming mold, prior to said first peeling step.

9. The method as claimed in Claim 2 or 3, further comprising:

15 a pressing step for pressing a central portion of said lens sheet

10 against said forming mold, prior to said first peeling step.

10. The method as claimed in Claim 4, further comprising:

20 a pressing step for pressing a central portion of said lens sheet

15 against said forming mold, prior to said first peeling step.

11. The method as claimed in Claim 5, further comprising:

15 a pressing step for pressing a central portion of said lens sheet

10 against said forming mold, prior to said first peeling step.

25 12. The method as claimed in Claim 6, further comprising:

a pressing step for pressing a central portion of said lens sheet against said forming mold, prior to said first peeling step.

13. The method as claimed in Claim 7, further comprising:

5 a pressing step for pressing a central portion of said lens sheet against said forming mold, prior to said first peeling step.

14. The method as claimed in Claim 1, wherein:

said pair of opposite portions are a pair of opposite diagonal edge portions of said lens sheet and said other pair of opposite portions are an other pair of opposite diagonal edge portions thereof.

10 15. The method as claimed in Claim 8, wherein:

said pair of opposite portions are a pair of opposite diagonal edge portions of said lens sheet and said other pair of opposite portions are an other pair of opposite diagonal edge portions thereof.

15 16. The method as claimed in Claim 1, wherein:

said pair of opposite portions are a pair of opposite side portions of said lens sheet and said other pair of opposite portions are an other pair of opposite side portions thereof.

17. The method as claimed in Claim 8, wherein:

20 said pair of opposite portions are a pair of opposite side portions of said lens sheet and said other pair of opposite portions are an other pair of opposite side portions thereof.

18. The method as claimed in Claim 1, wherein:

25 said first peeling step comprises a plurality of first sequential sub-steps for pulling up said pair of opposite portions by a first prescribed pulling stroke;

said second peeling step comprises a plurality of second

sequential sub-steps for pulling up said other pair of opposite portions by a second prescribed pulling stroke; and

 said first peeling step and said second peeling step are conducted alternately.

5 19. The method as claimed in Claim 8, wherein:

 said first peeling step comprises a plurality of first sequential sub-steps for pulling up said pair of opposite portions by a first prescribed pulling stroke;

10 said second peeling step comprises a plurality of second sequential sub-steps for pulling up said other pair of opposite portions by a second prescribed pulling stroke; and

 said first peeling step and said second peeling step are conducted alternately.

20 20. The method as claimed in Claim 18, wherein:

15 said first prescribed pulling stroke increases according as number of said first sequential sub-steps increases; and

 said second prescribed pulling stroke increases according as number of said second sequential sub-steps increases.

21. The method as claimed in Claim 19, wherein:

20 said first prescribed pulling stroke increases according as number of said first sequential sub-steps increases; and

 said second prescribed pulling stroke increases according as number of said second sequential sub-steps increases.

22. An apparatus for peeling a lens sheet having two pairs of
25 opposite portions from a forming mold, comprising:

 a first lifting device for pulling up a pair of opposite portions of a lens sheet, which is to be formed on a forming mold;

a second lifting device for pulling up an other pair of opposite portions of said lens sheet; and

5 a control device for controlling said first and second lifting devices on a basis of any one of (i) a first operation mode that the pulling up of said pair of opposite portions of said lens sheet by said first lifting device and the pulling up of said other pair of opposite portions thereof by said second lifting device are conducted simultaneously to peel partially said lens sheet from said forming mold, and then both of said pair of opposite portions of said lens sheet and
10 said other pair of opposite portions thereof are further pulled up by means of said first and second lifting devices to peel entirely said lens sheet from said forming mold, and (ii) a second operation mode that the pulling up of said pair of opposite portions of said lens sheet by said first lifting device and the pulling up of said other pair of opposite portions thereof by said second lifting device are conducted at a different time to peel partially said lens sheet from said forming mold, and then both of said pair of opposite portions of said lens sheet and said other pair of opposite portions thereof are further pulled up by means of said first and second lifting devices to peel entirely said lens
15 sheet from said forming mold,
20 sheet from said forming mold.

23. The apparatus as claimed in Claim 22, further comprising:

 a pressing device for pressing a central portion of said lens sheet against said forming mold.

24. The apparatus as claimed in Claim 22, wherein:

25 said first and second lifting devices comprises a plurality of suction cups.

25. The apparatus as claimed in Claim 23, wherein:

5 said first and second lifting devices comprises a plurality of suction cups.

26. The apparatus as claimed in Claim 22, wherein:

10 said first and second lifting devices comprises a plurality of
5 clamping members.

27. The apparatus as claimed in Claim 23, wherein:

15 said first and second lifting devices comprises a plurality of
clamping members.

28. The apparatus as claimed in Claim 22, wherein:

20 said control device controls said first and second lifting devices so that a plurality of first sequential sub-steps for pulling up said pair of opposite portions by a first prescribed pulling stroke are conducted by said first lifting device, a plurality of second sequential sub-steps for pulling up said other pair of opposite portions by a second prescribed pulling stroke are conducted by said second lifting device, and said plurality of first sequential sub-steps and said plurality of second sequential sub-steps are conducted alternately.

25 29. The apparatus as claimed in Claim 23, wherein:

20 said control device controls said first and second lifting devices so that a plurality of first sequential sub-steps for pulling up said pair of opposite portions by a first prescribed pulling stroke are conducted by said first lifting device, a plurality of second sequential sub-steps for pulling up said other pair of opposite portions by a second prescribed pulling stroke are conducted by said second lifting device, and said plurality of first sequential sub-steps and said plurality of second sequential sub-steps are conducted alternately.

30. The apparatus as claimed in Claim 28, wherein:

 said control device controls said first and second lifting devices so that said first prescribed pulling stroke increases according as number of said first sequential sub-steps increases; and said second prescribed pulling stroke increases according as number of said second sequential sub-steps increases.

31. The apparatus as claimed in Claim 29, wherein:

 said control device controls said first and second lifting devices so that said first prescribed pulling stroke increases according as number of said first sequential sub-steps increases; and said second prescribed pulling stroke increases according as number of said second sequential sub-steps increases.